

Work Order ID 131444

131444

Page 1

Wednesday, April 08, 2015 3:00:32 PM

Item ID: K469-004-003

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clevis Fitting

Start Date: 4/8/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/8/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date: 15-4-08

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100 Manufacture as per dwg

0.00

100

Mill Conv

Memo

0.09

Conventional Milling Machine

4

Ø

J.C.L

15/04/16

110 QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4

Ø

J.C.L

15/04/16

120 QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

4

DAS

38

9-89

APR 21 2015

PTO

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Page 2

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Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS
130 *130* SprayPaint Spray Painting	Spray Painting per QSI005 4.2 <i>White</i> Memo PRIME IAW MIL-P-23377 J TYPE I CLASS N PAINT TWO COATS ALIPHATIC POLYURETHANE CHEM AGENT RESISTANT MIL-C-46168 TYPE 2	0.00 0.00				4			41 9-89 15-5-3
									PAINT & PRIME AS PER QSI 005
									Prime 131846 Paint 132024
140 *140* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00							5/1/2015 DAS 38 MAY 04 2015
									(4)
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST523</i> Memo	0.00 0.00							MAR 04 2015

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Wednesday, April 08, 2015 3:00:32 PM

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N9000040100

Setup Start *NS1*

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Stop *NS2*

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Start Date: 4/8/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/8/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MAY 04 2015

MS 5-4

Picklist Print

Wednesday, April 08, 2015 3:00:38 PM

Page 1

Work Order ID: 131444

131444

Parent Item: K469-004-003

K469-004-003

Parent Item Name: Clevis Fitting

Start Date: 4/8/2015

Required Date: 4/8/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 15-04-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B3.500X02.00 0		Purchased	No				f	30.8000		2			

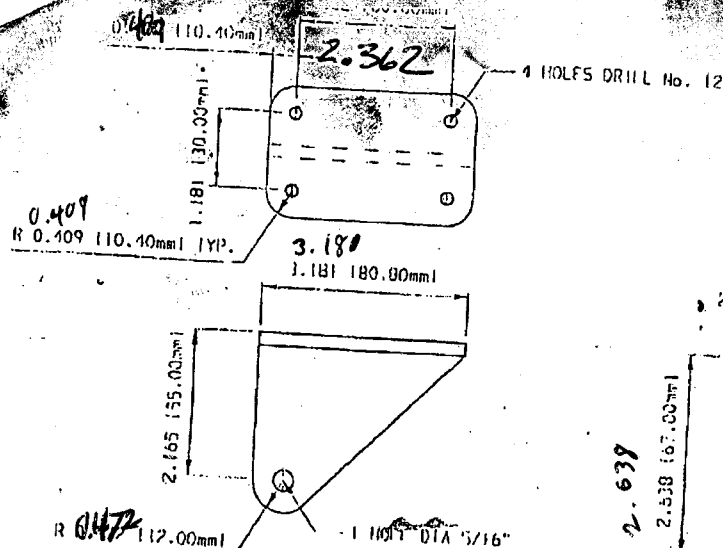
M7075T6B3 500X02 000

7075-T6 BAR 3.500" X 2.000"

** J.C. - 15/04/14

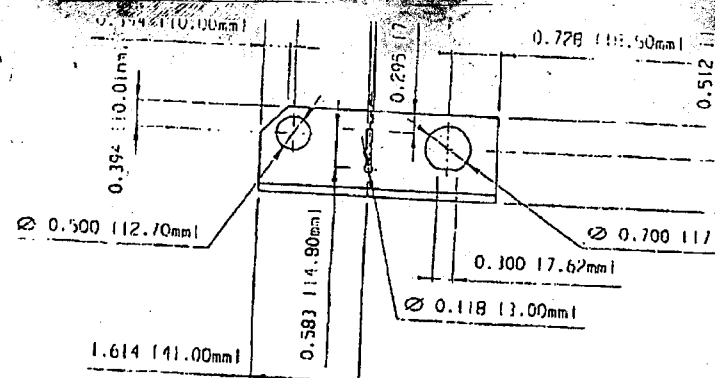
Location	Loc Qty	Loc Code
MAT006	30.8	
M123555	3.9	
M125623	2.9	
M127736	24	

1.12' 40.276'



DETAIL OF PART No. 169 004 003 (103)

APPROVED pursuant to a direction given by Regulation 35 of the Civil Aviation Regulations on date: 15-4-98
signature: C.W. Whitney
name: C.W. WHITNEY
being an Authorised Person for and on behalf of Helitech Pty Ltd
Certificate of Approval 3300
A.C.N. 010 600 987



DETAIL OF PART No. 169 004 005 (109)

NOTES

1. COMMERCIAL MATERIALS MUST BE SUPPLIED UNDER COVER OF N.A.I.A. CERTIFICATE FOR CHEMICAL PROPERTIES AND HARDNESS TO AS1866-1986.
2. VISUALLY CHECK FOR CORROSION PITTING, STRAIGHTNESS AND FREEDOM FROM KINKS, DENTS AND HEAVY SCRATCHING.

ITEM	QTY	UNIT	PART No.	DESCRIPTION	MATERIAL/ORIGINAL PART #	SIZE	GRADE	MAT. SPEC.
109	1		169 004 001	CABLE BRACKET	1.0x1.5x0.100" A/A FOR ANG EXI	2024	00 A-250/5	
107	1		169 004 004	CABLE BRACKET	0.75x1.5x0.100" A/A FOR ANG EXI	2024	00 A-250/5	
103	2		169 004 003	CLAVIS FITTING	2.0x1.0x0.190" ALUM. ALLOY	7075	00 A-200/11	
102	1		169 004 002	SPIGOT FITTING	2.0x1.0x0.190" ALUM. ALLOY	7075	00 A-200/11	
58	2		15805	DOUBLER	1.0x0.111" ALUM ALLOY TUBE	2024	MIL. T 6060	
40	2		158 012 001	LANYARD	1/32" STAINLESS STEEL WIRE			
11	12		158 006 001	OLCKET EXTRUSION	60 1087 EXTRUSION			
10	4		158 001 001	SPINSON PIVOT	1.250" DIA ALUMIN. ALLOY BAR	2024	00 A-200 IF	
109	1		169 004 001	CABLE BRACKET	1.0x1.5x0.100" A/A FOR ANG EXI	2024	00 A-250/5	
107	1		169 004 004	CABLE BRACKET	0.75x1.5x0.100" A/A FOR ANG EXI	2024	00 A-250/5	
103	2		169 004 003	CLAVIS FITTING	2.0x1.0x0.190" ALUM. ALLOY	7075	00 A-200/11	
102	1		169 004 002	SPIGOT FITTING	2.0x1.0x0.190" ALUM. ALLOY	7075	00 A-200/11	
58	2		15805	DOUBLER	1.0x0.111" ALUM ALLOY TUBE	2024	MIL. T 6060	
40	2		158 012 001	LANYARD	1/32" STAINLESS STEEL WIRE			
11	12		158 006 001	OLCKET EXTRUSION	60 1087 EXTRUSION			
10	4		158 001 001	SPINSON PIVOT	1.250" DIA ALUMIN. ALLOY BAR	2024	00 A-200 IF	
109	1		169 004 001	CABLE BRACKET	1.0x1.5x0.100" A/A FOR ANG EXI	2024	00 A-250/5	
107	1		169 004 004	CABLE BRACKET	0.75x1.5x0.100" A/A FOR ANG EXI	2024	00 A-250/5	
103	2		169 004 003	CLAVIS FITTING	2.0x1.0x0.190" ALUM. ALLOY	7075	00 A-200/11	
102	1		169 004 002	SPIGOT FITTING	2.0x1.0x0.190" ALUM. ALLOY	7075	00 A-200/11	
58	2		15805	DOUBLER	1.0x0.111" ALUM ALLOY TUBE	2024	MIL. T 6060	
40	2		158 012 001	LANYARD	1/32" STAINLESS STEEL WIRE			
11	12		158 006 001	OLCKET EXTRUSION	60 1087 EXTRUSION			
10	4		158 001 001	SPINSON PIVOT	1.250" DIA ALUMIN. ALLOY BAR	2024	00 A-200 IF	
109	1		169 004 001	CABLE BRACKET	1.0x1.5x0.100" A/A FOR ANG EXI	2024	00 A-250/5	
107	1		169 004 004	CABLE BRACKET	0.75x1.5x0.100" A/A FOR ANG EXI	2024	00 A-250/5	
103	2		169 004 003	CLAVIS FITTING	2.0x1.0x0.190" ALUM. ALLOY	7075	00 A-200/11	
102	1		169 004 002	SPIGOT FITTING	2.0x1.0x0.190" ALUM. ALLOY	7075	00 A-200/11	
58	2		15805	DOUBLER	1.0x0.111" ALUM ALLOY TUBE	2024	MIL. T 6060	
40	2		158 012 001	LANYARD	1/32" STAINLESS STEEL WIRE			
11	12		158 006 001	OLCKET EXTRUSION	60 1087 EXTRUSION			
10	4		158 001 001	SPINSON PIVOT	1.250" DIA ALUMIN. ALLOY BAR	2024	00 A-200 IF	
109	1		169 004 001	CABLE BRACKET	1.0x1.5x0.100" A/A FOR ANG EXI	2024	00 A-250/5	
107	1		169 004 004	CABLE BRACKET	0.75x1.5x0.100" A/A FOR ANG EXI	2024	00 A-250/5	
103	2		169 004 003	CLAVIS FITTING	2.0x1.0x0.190" ALUM. ALLOY	7075	00 A-200/11	
102	1		169 004 002	SPIGOT FITTING	2.0x1.0x0.190" ALUM. ALLOY	7075	00 A-200/11	
58	2		15805	DOUBLER	1.0x0.111" ALUM ALLOY TUBE	2024	MIL. T 6060	
40	2		158 012 001	LANYARD	1/32" STAINLESS STEEL WIRE			
11	12		158 006 001	OLCKET EXTRUSION	60 1087 EXTRUSION			
10	4		158 001 001	SPINSON PIVOT	1.250" DIA ALUMIN. ALLOY BAR	2024	00 A-200 IF	

Client

HELITECH PTY. LTD.

Title

KWIK FLOAT INSTALLATION
PARTS DETAIL
BELL 206 A & B SERIES

IRN

325

CI

117, 118

Drawing Number

BHA/DRA/358-02-02

REFERENCE ONLY

Helitech
PTY LTD

BRISBANE (HQ) 10/11
11 AMINGTON AVE, LAGLEIGH
Incorporated in Queensland

PHONE: (07) 32684077
FAX: (07) 32607015
AS 1100

Helitech Pty Ltd (1998)

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DRAWN

NORA KINNUNEN

DATE

15/04/98

SCALE

1:2

CHECKED BY

C.W. WHITNEY

DATE PLOTTED

15/04/98

DART AEROSPACE LTD	Work Order: 131 444
Description:	Part Number: 469.004 003
Inspection Dwg: 469-004 Rev: N/A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	± 0.010	2.000	✓		Vern.	JCL-08
2.638	± 0.010	2.638	✓		"	
0.190	± 0.010	0.190	✓		"	
0.190	± 0.010	0.195	✓		"	
3.181	± 0.010	3.181	✓		"	
Ø0.189(#12)	± 0.005 -0.001	0.191	✓		"	
0.409	± 0.010	0.408	✓		"	
2.362	± 0.010	2.362	✓		"	
1.181	± 0.010	1.179	✓		"	
2.165	± 0.010	2.166	✓		"	
R 1/8	± 0.030	0.125	✓		Rad. Gauge	
R 0.409	± 0.010					
R 0.472	± 0.010					
Ø0.3125	± 0.006 -0.001	0.313	✓		Vern.	JCB-08

Measured by: J.C.-L	Audited by: JAS 38 989	Preliminary Approval:
Date: 15/04/16	Date: APR 21 2015	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15

NGR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Ant Date: 15/05/20QA Closed: REM Date: 15/05/20

Work Order: <u>131 444</u> Part No. <u>469-004-003</u> NCR No. <u>15-4986</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☒	<u>15.04.20</u>	<u>100</u>	<u>1</u>	<u>GUDGE IN ROUNDED END NEAR Ø0.311 HOLE</u>	<u>A.P.</u> <u>15.04.20</u>	<u>SCRAP & REPLACE, CRITICAL FASTENING POINT FOR BLISK FLOAT SYSTEM</u> <u>batch #: M125623</u>	<u>J.C.L.</u> <u>15/04/20</u>	<u>M.G.</u> <u>15/04/20</u>	<u>DAS</u> <u>9</u> <u>9-89</u> <u>15.04.21</u> <u>DAS</u> <u>08</u> <u>9-89</u>
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☒ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Mislabeled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other